

2

Date: Wednesday, 12/5/2007 8:01:52 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LONG STEP ASSEMBLY HIGH SKID RH
 Job Number : 36108
 Estimate Number : 10274
 P.O. Number :
 This Issue : 12/5/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LARGE FAB ASSY
 Previous Run : 36107
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 04.03.22 New issue KJ/RF
 Est Rev:B 07-06-09 Added D3572-1 JLM

Part Number : D350591312
 Drawing Number : D3272 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 1/10/2008 Qty: 10 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

07.12.12 H

2.0 D32721 STEP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STEP

BATCH: 35805

H 07.12.27 8

3.0 D30671 End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1 End Plate 335804

H 07.12.27 8

4.0 D32191 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3219-1 Support 336114

H 07.12.27 8

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Job Number: 36108

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M105058*
M105844

3-Grind End Plate flush

a.m.

08.01.02

8

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1/08/01/02 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/02 x 8 RH

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m.

08.01.02

(8)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.01.16 8

10.0

D3065041

Step Leg Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3065-041 Step Leg Assy *335622*

08.01.16 8

11.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3066-1 Spacer *335692*

08.01.16 8

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Job Number: 36108

Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

M106302

PH 08.01.16 8

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble Leg Assembly as per Dwg D3272.

PH 08.01.16 8

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08.01.16 (RH)

15.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

335804

PH 08.01.16 8

16.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod M105058

4-Grind End Plate flush

SAD 08.01.17

(8)

5-Install last rivet.

PH 08.01.16 8
PH 08.01.16 8
PH 08.01.16 8
PH 08.01.16 8

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Process Sheet

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Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-17 (8)

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/18 (8) RN

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

SAD 08/01/20

20.0

POWDER COATING

POWDER COATING



M106379



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/01/21

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



m106332



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3272 and QSI 005 4.4

FD 08/01/21 (8)

22.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

08/01/22 (8)

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-3 Mounting Lug 35800

08/01/21 (8)

Dart Aerospace Ltd

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Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

D2618

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2618 Bushing 35096

26.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2856-400-720 Abrasion Strip 35900

27.0

D32351

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3235-1 Mounting Lug 30996

33099

28.0

D3278041

Support Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3278-041 Support Assembly 36119

29.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt 105608

30.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-13A Bolt 106513

8/10/121 (8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

AN536A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN5-36A

Bolt

106242

9x

M10x513

7x

CC

32.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10

Washer

106167

33.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 AN960JD416

Washer

108906

34.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD516

Washer

106167

35.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3

Nut (or -3)

105858

CC 8/01/21 (S)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part Number: D350591312

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4

Nut (or -4)

1105057

37.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L5

Nut (or -5)

105940

38.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

ALL kits sealed in bags & placed in box.

39.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-312

Location:

B

8/1/23

50

8x

40.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.01.23

9

Job Completion



u 08.01.23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED07.06.04 *H*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

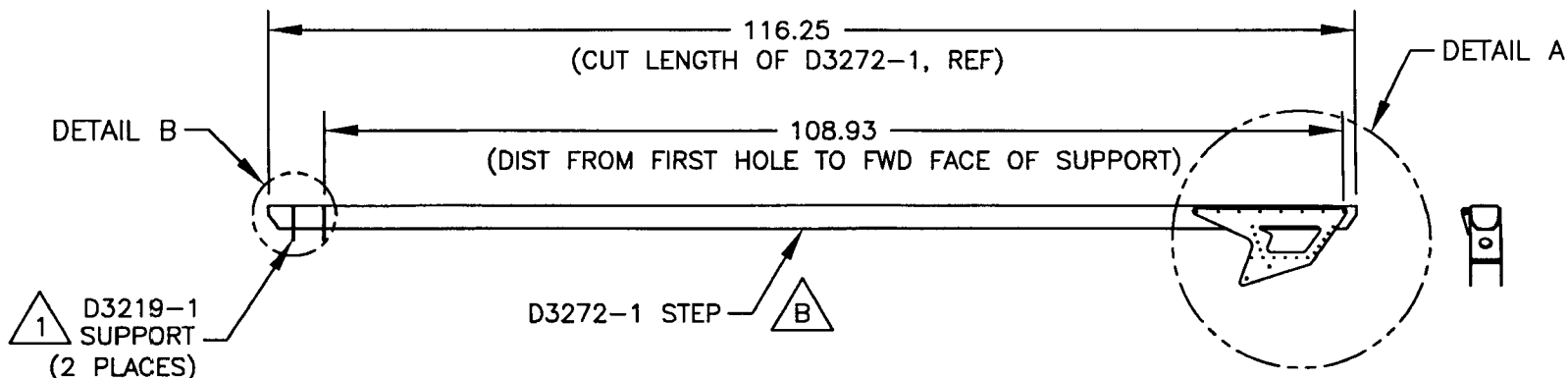
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36108

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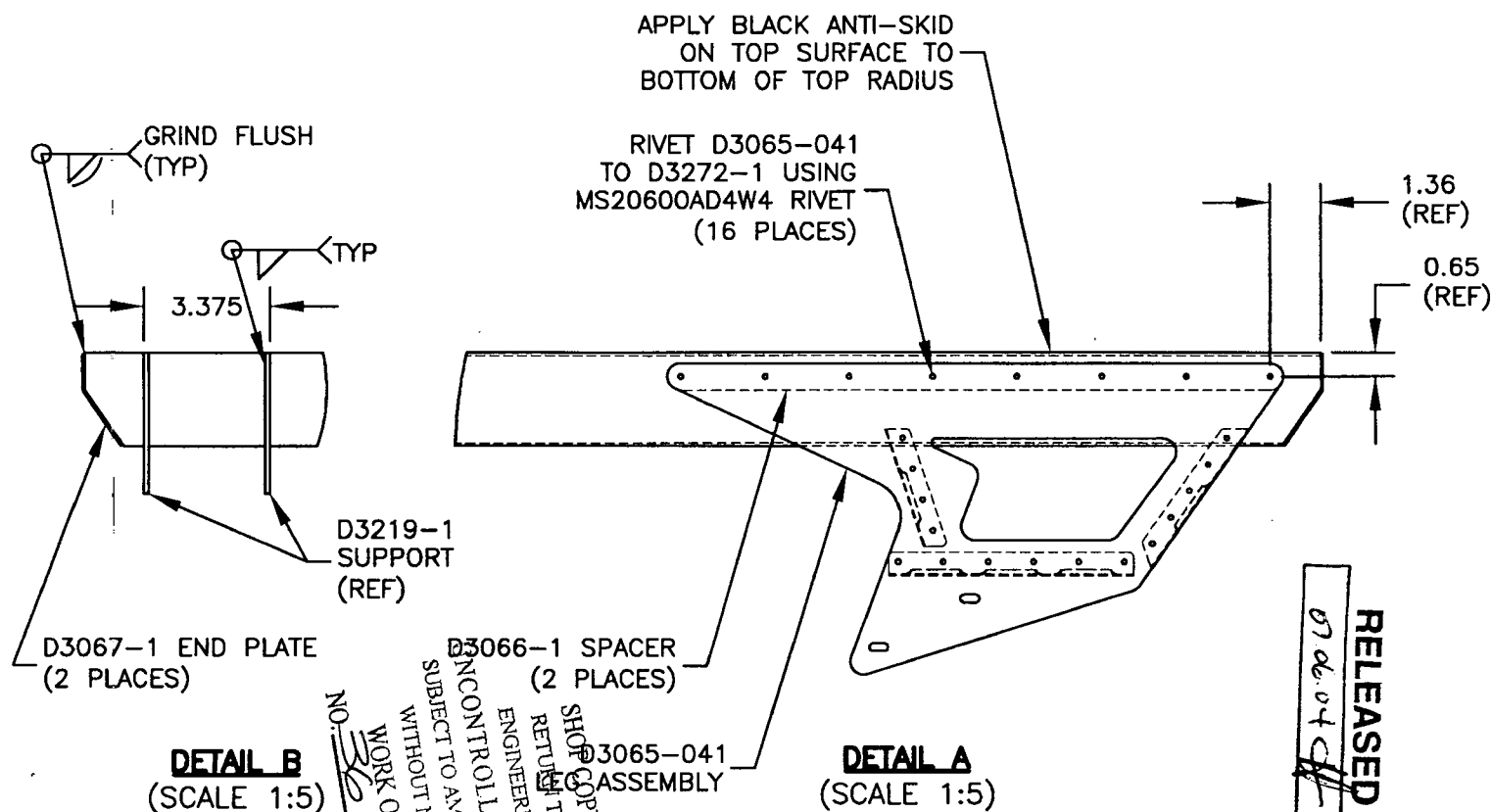
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DART

| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
|----------------------|---------------------------------|---|---------------|
| CHECKED <i>CE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B |
| DATE 07.05.18 | TITLE STEP ASSEMBLY, HI LONG | SHEET 2 OF 3 | SCALE 1:20 |



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



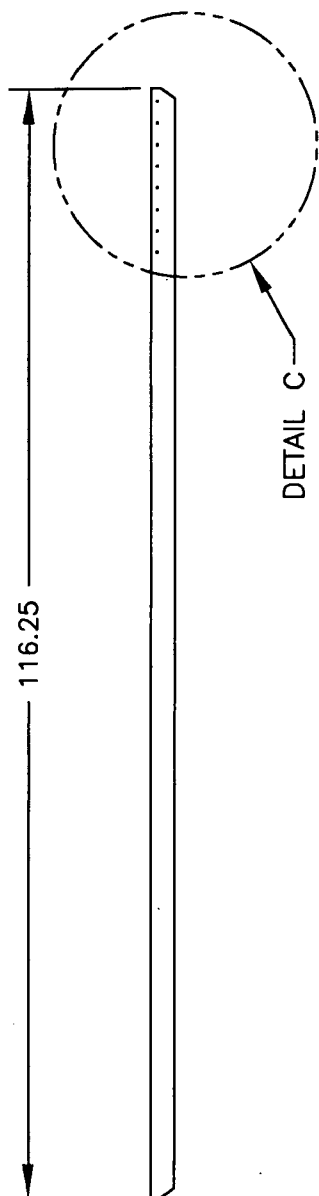
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D3065-041
ASSEMBLY



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| DESIGN <i>GP</i> | DRAWN BY <i>JB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

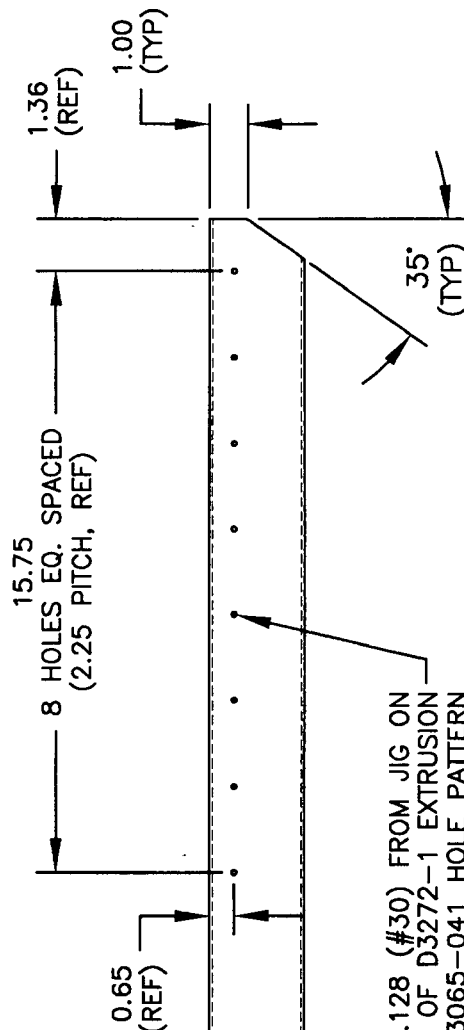
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

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WITHOUT NOTICE
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